

## Quality Control

12

12/04/10

1 BR 124-10.

Sizbeho



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81412****\*81412\***

Page 2

March-14-12 7:51:10 AM

Item ID: D4030-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*130\***

Packaging

Memo

PNA 81382

0.00

Packaging

644/11

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

MLJ 12/04/16

MLJ 12/04/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

March-14-12 7:51:15 AM

Page 1

Work Order ID: 81412

\*81412\*

Parent Item: D4030-041

\*D4030-041\*

Parent Item Name: Long Basket Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

69500

is

D4086-220

ed Date: 27/03/2012

ed Qty: 1.00

8

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	
D4086-210		Manufactured	No				Ea

\*D4086-210\*

Placard, Max Load

per NCR 121239

## Location

## Loc Qty

## Loc Code

ST122

4

66275

1

76298

3

ST124

1

64869

1

D2530

\*D2530\*

Handle Weldment

Manufactured

No

100

Each

9.0000

1

1

\*\*

1322827 50

## Location

## Loc Qty

## Loc Code

ST506

9

77030

3

78965

6

D2535

\*D2535\*

Spring

Manufactured

No

100

Each

44.0000

2

2

\*\*

BL 124-00.

JB 12/04/10

## Location

## Loc Qty

## Loc Code

ST504

44

77488

44

77488

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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March-14-12 7:51:15 AM

Page 2

Work Order ID: 81412

**\*81412\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2537

Manufactured No

100

Each

34.0000

2

2

✓

**\*D2537\***

Bushing

\*\*

JB

Location

Loc Qty

Loc Code

ST504

34

77055

34

77055

D3913-041

Manufactured No

100

Each

0.0000

1

1

**\*D3913-041\***

Long Basket Base Assembly, 350

\*\*

1

BL 12-4-10.

D3914-041

Manufactured No

100

Each

0.0000

1

1

**\*D3914-041\***

Long Basket Lid Assembly (350)

\*\*

1

BL 12-4-10.

D3917-3

Manufactured No

100

Each

19.0000

6

6

✓

**\*D3917-3\***

Washer

\*\*

81205

JB

Location

Loc Qty

Loc Code

ST070

19

76956

4

80598

15

D3953-3

Manufactured No

100

Each

26.0000

2

2

✓

**\*D3953-3\***

Gas Spring Stud, Lid

\*\*

JB

12/04/10

Location

Loc Qty

Loc Code

ST075

26

76659

6

78042

20

78042

W/O:		WORK ORDER CHANGES					
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March-14-12 7:51:15 AM

Page 3

Work Order ID: 81412

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

\*81412\*

\*D4030-041\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-7 Manufactured No

100 Each

14.0000

2

2

\*\*

82045 JB

\*D3953-7\*

Spring Spacer

Location

Loc Qty

Loc Code

ST075

14

76295

14

D3953-9 Manufactured No

100 Each

18.0000

2

2

\*\*

1482035 JB

\*D3953-9\*

Gas Spring Washer

Location

Loc Qty

Loc Code

ST075

18

78916

18

D3953-17 Manufactured No

100 Each

7.0000

2

2

\*\*

1X78916

81454 JB

\*D3953-17\*

Gas Spring Spacer

Location

Loc Qty

Loc Code

ST075

7

76294

7

D3953-19 Manufactured No

100 Each

14.0000

1

1

\*\*

JB

\*D3953-19\*

Gas Spring Bracket

Location

Loc Qty

Loc Code

ST075

14

75227

14

D3953-21 Manufactured No

100 Each

1.0000

1

1

\*\*

75227

81207 JB 12/04/10

\*D3953-21\*

Gas Spring Bracket

Location

Loc Qty

Loc Code

ST075

1

73557

1

March-14-12 7:51:15 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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March-14-12 7:51:15 AM

Page 4

Work Order ID: 81412

\*81412\*

Parent Item: D4030-041

\*D4030-041\*

Parent Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

100 Each 15.0000 1 1 ✓

\*D3969-3\*

Spring (Basket Lid)

\*\*

JB

## Location

## Loc Qty

## Loc Code

ST272

15

64285

1

73515

14

73515

AN3-14A Purchased No

100 Each 96.0000 4 4 ✓

\*AN3-14A\*

Bolt

\*\*

JB

## Location

## Loc Qty

## Loc Code

ST352

96

119328

96

119328

AN3-16A Purchased No

100 Each 137.0000 2 2 ✓

\*AN3-16A\*

Bolt

\*\*

JB

## Location

## Loc Qty

## Loc Code

ST352

137

117441

49

118628

38

120986

50

118628

AN5-17A Purchased No

100 Each 84.0000 4 4 ✓

\*AN5-17A\*

Bolt

\*\*

2x121181 JB 12/04/10

## Location

## Loc Qty

## Loc Code

ST338

84

117872

42

120498

42

2x120498

March-14-12 7:51:16 AM

Shop Packet Print

Page 4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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March-14-12 7:51:16 AM

Page 5

Work Order ID: 81412

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

**\*81412\***

**\*D4030-041\***

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No

100 Each 89.0000 3 3 ✓

**\*AN4-12\***

Bolt

\*\*

JB

Location

Loc Qty

Loc Code

ST357

89

118626

14

119775

25

120986

50

120986

AN310-4 Purchased No

100 Each 75.0000 3 3 ✓

**\*AN310-4\***

NUT

\*\*

JB

Location

Loc Qty

Loc Code

ST344

75

120124

25

120518

25

121011

25

121011

AN310C4 Purchased No

100 Each 49.0000 2 2 ✓

**\*AN310C4\***

Nut

\*\*

121166 JB

12/04/10

Location

Loc Qty

Loc Code

ST344

49

119324

19

120360

30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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March-14-12 7:51:16 AM

Page 6

Work Order ID: 81412

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

\*81412\*

\*D4030-041\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

3,192.000

6

6

✓

\*MS21042I 3\*

Nut

\*\*

JB

Location

Loc Qty

Loc Code

ST300

3192

117441

16

117885

32

118451

5

118927

3

119017

2956

119075

180

119017

MS21042L5

Purchased

No

100

Each

1,618.000

4

4

✓

\*MS21042I 5\*

Nut

\*\*

JB

Location

Loc Qty

Loc Code

ST300

1618

116105

5

116548

43

117611

42

118179

28

119109

1500

119109

MS24665-151

Purchased

No

100

Each

315.0000

3

3

✓

\*MS24665-151\*

Cotter Pin

\*\*

JB 12/04/10

Location

Loc Qty

Loc Code

ST309

315

17566

315

17566

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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# Picklist Print

March-14-12 7:51:16 AM

Page 7

Work Order ID: 81412

**\*81412\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

210.0000

2

2

✓

**\*MS24665-300\***

Cotter Pin

\*\*

*JB*

Location

Loc Qty

Loc Code

GA

200

118234

200

118234

ST309

10

116823

10

NAS1149F0432P

Purchased

No

100

Each

298.0000

6

6

✓

**\*NAS1149F0432P\***

Washer

\*\*

121166

*JB*

Location

Loc Qty

Loc Code

ST275

298

118840

32

119307

64

120142

2

120360

200

NAS1149F0563P

Purchased

No

100

Each

93.0000

4

4

✓

**\*NAS1149F0563P\***

Washer

\*\*

117735

*JB 12/04/10*

Location

Loc Qty

Loc Code

ST275

93

117735

93

117735

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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March-14-12 7:51:16 AM

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Work Order ID: 81412

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

**\*81412\***

**\*D4030-041\***

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

782.0000

8

8

\*\*

12146 JB

**\*NAS1149F0332P\***

WASHER

Location

Loc Qty

Loc Code

ST275

782

117735

37

119225

142

120498

200

120910

200

120986

200

17317

3

NAS1149C0432R

Purchased

No

100

Each

2,618.000

2

2

\*\*

JB 12/04/10

**\*NAS1149C0432R\***

Washer

Location

Loc Qty

Loc Code

ST297

2618

117291

1618

119124

1000

117291

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

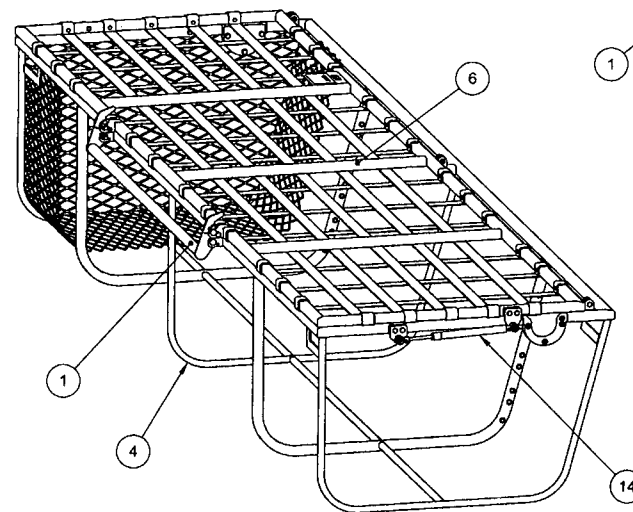
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

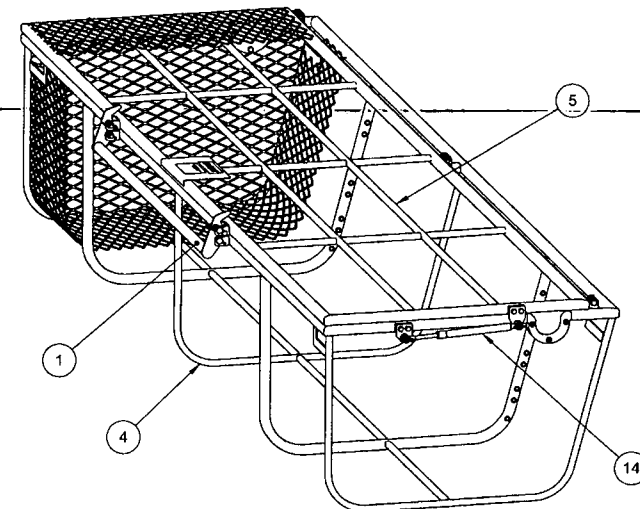
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



**D4030-043 LONG BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)



**D4030-041 LONG BASKET ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 81412 MLJ  
12/03/14

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX  
-043: 57 lbs APPROX

**RELEASED**  
10-08-12-4  
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALJ		
DRAWN	J		
CHECKED	J		
MFG. APPR.	JFS		
APPROVED	J		
DE APPR.	J		
DATE	10.07.23		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4030</b> TITLE <b>LONG BASKET ASSY (350)</b> REV. C SHEET 1 OF 3 SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
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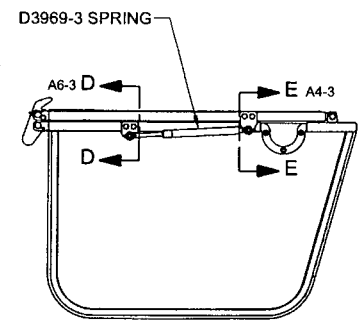
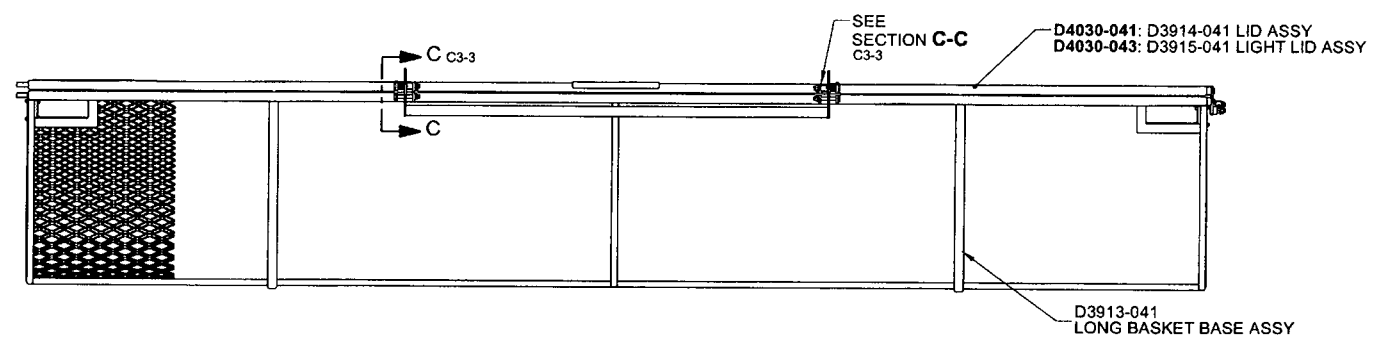
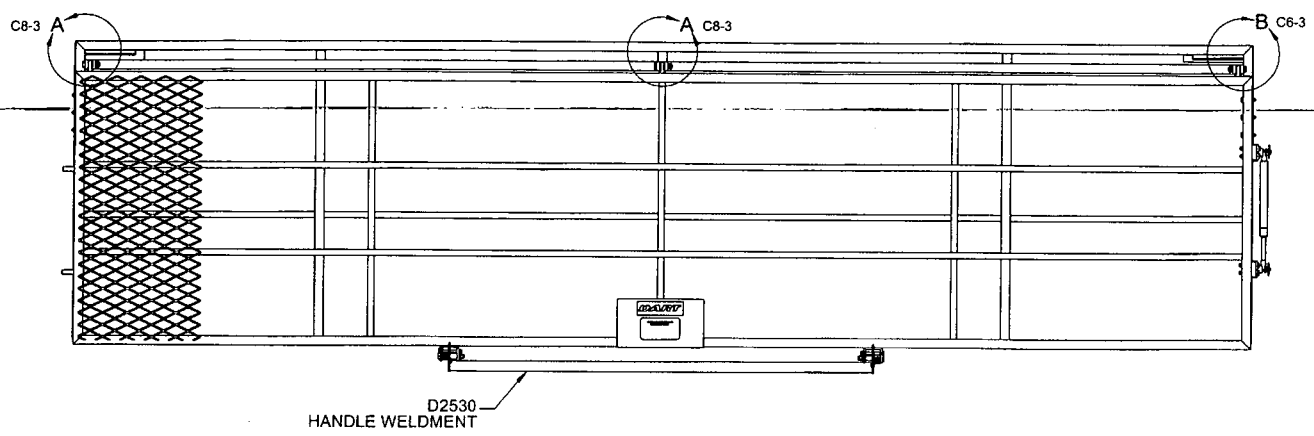
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

81472



**D4030-041 LONG BASKET ASSY (350) (SHOWN)**  
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

**D4030-043 SHORT BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
10.08.12 CP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SEP 10 2010	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	___ NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

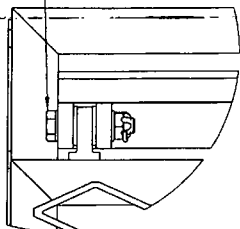
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

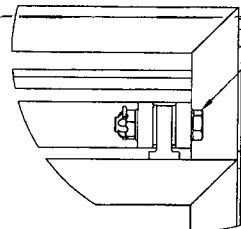
**NOTE:** Date & initial all entries



AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



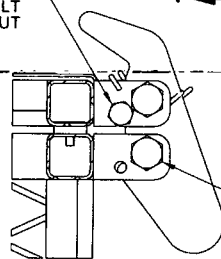
**DETAIL A** D8-2  
D5-2



**DETAIL B** D3-2

AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN

D4030-041: AN3-16A BOLT  
MS21042L3 NUT  
D4030-043: AN3-20A BOLT  
MS21042L3 NUT

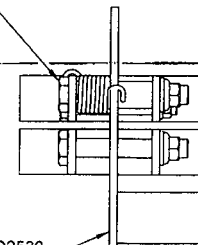


**SECTION C-C** B4-2  
B6-2

D4030-041: AN5-17A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

D4030-043: AN5-21A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

AN5-17A BOLT  
NAS1149F0563P WASHER  
MS21042L5 NUT



D2530  
HANDLE WELDMENT  
REF

**VIEW F-F** C3-3

D3953-17 GAS SPRING SPACER  
D3953-21 GAS SPRING BRACKET  
AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION D-D** B2-2

D3953-17 GAS SPRING SPACER  
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION E-E** B1-2

**RELEASED**  
10.08.124

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	J.F.S. BTLA	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries